

Work Order ID 57968

April 21, 2010 9:21:42 AM



Page 1

Item ID: D4038-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle. Aft, RH

Start Date: 23/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 4.00

Customer:

Reference:

Full

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4038

B

100

0.00



Bandsaw

Memo

7.625 m

0.00

Jeaspa Bandsaw

Cut Blank *7.125* long

10/04/21

4 1

110

0.00



HAAS 1

Memo

Mill as per Dwg & Folio FA880

Dwg Rev: *03*

Folio Rev: *03*

0.00

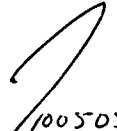

HAAS CNC vertical machine #1

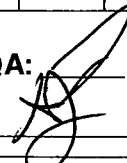
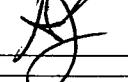
Deburr



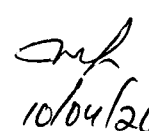
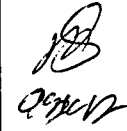
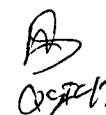

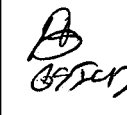
m J 10/04/25

21 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
100505	100	Change the cut length, is incorrect per NCR below. Change to 7.625" long per machinist request. perm change				 100505	 100505

Part No: D4038-4 PAR #: _____ Fault Category: Prod-eng-corrld. NCR: Yes No DQA:  Date: 100505
Resolution: scr w Disposition: scr w QA: N/C Closed:  Date: 10/05/04

NCR: <u>57968</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/05	100	Blank are cut too short w/o step 100 is wrong Blank are 7.125 should be 7.625 Part is 7.500 long	 09/27/12	Use blank for next 4038-2 300 Replace M113391 x 1 Not enough material	 10/04/05	 10/04/26	 09/27/12	S 10/04/26
		RL work order is wrong should be 7.75 not 7.25" LOA.	 09/27/12	Fix w/o Detail See above. Procedure change			 09/27/12	S 10/04/26

NOTE: Date & initial all entries

Work Order ID 57968

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

mz 10/04/25

1 4 blank

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

LS 10/04/27

1 4

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

HL 10/04/28

1 0

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

① 10-4-28

160

Identify as per dwg & Stock Location: 1:1

0.00



Packaging

Memo

0.00

Packaging

10-4-28 (ix) SF

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/29 J
B/10-4-29
①

Picklist Print

April 21, 2010 9:21:42 AM

Page 1

Work Order ID: 57968

Parent Item: D4038-4

Parent Item Name: Angle. Aft. RH

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Start Date: 23/04/2010

Required Date: 30/04/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased	No			100	f	14.5000	2.9474			



6061T6 ANGLE 4.00 x 4.00 x .250

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT06

113391

14.5

14.5

mw
10/04/21

2.9474 + .6672

DART AEROSPACE LTD		Work Order: 57968
Description: Angle, A44, RH		Part Number: D4038-4
Inspection Dwg: 4038	Rev: B	Page 1 of 1

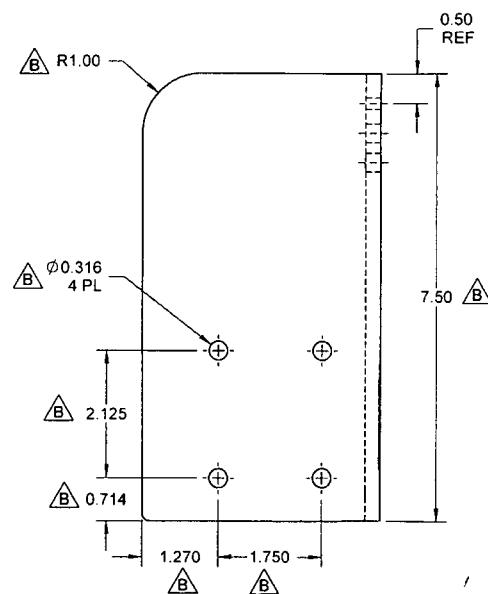
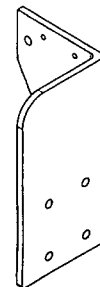
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.50	± .03	7.50	✓			
4.00	± .03	4.00	✓			
1.750	± .010	1.753	✓			
1.270	± .010	1.266	✓			
2.125	± .010	2.122	✓			
.714	± .010	.711	✓			
1.500	± .010	1.497	✓			
1.000	± .010	1.000	✓			
.500	± .010	.500	✓			
2.00	± .03	2.00	✓			
2.904	± .010	2.906	✓			
.669	± .010	.669	✓			
.70	± .03	.70	✓			
.581	± .010	.579	✓			
Ø .316	+ .006 - .001	.317	✓			
Ø .189	+ .005 - .001	.191	✓			

Measured by: <i>mw</i>	Audited by: <i>SB</i>	Prototype Approval:	N/A
Date: 10/04/25	Date: 10/04/27	Date:	N/A


Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



RELEASE
2010-04-14
md

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T644.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (FAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.19 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D4038	SHEET 6 OF 14
MFG. APPR.		TITLE	SCALE
APPROVED		BRACKET	NTS
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRINTED AND REPRODUCED, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR OR FOR PURPOSES OR CONSIDERED TO BE FOR ANY OTHER PAPER OR METHOD</small>	
DATE	10.01.05		